

Work Order ID 86557

86557

Page 1

July-03-12 10:22:51 AM

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, LH
 Start Date: 7/05/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2351	Rev E

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-121 CHG005								

110	Large Fab	0.00							
110									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G								
	2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.								
	3-Deburr								

MLJ 12-09-19

4 ϕ Ae 12.07.09

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Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* CNC Bend 1 CNC Delta 100 Bender	BENDING MACHINE - SKIDTUBES Memo Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.	0.00 0.00							
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	8		
140 *140* Large Fab Large Fab	Large Fab Memo 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod 3-Do not Grind Flush	0.00 0.00				4	8		12.08.20

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July-05-12 10:22:51 AM

Item ID: D350-591-121 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, LH
 Start Date: 7/05/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				DAS 09 2-89	12-08-29		
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				DAS 16 2-89	12/08/30		
170 *170* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				DAS 16 2-89	4641	12/09/10	

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July-05-12 10:22:51 AM

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Heli-Access-Step, LH
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4x	0		mrt 12/09/04
190 *190* Large Fab Large Fab	Large Fab Memo 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod <u>122358</u> 3-Grind end cap flush per dwg D2351	0.00 0.00				4	0		ke 12.09.06 12.09.07 Ae 12.09.12
220 *220* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	DA 16 -3	17/09/14		4			

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Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Heli-Access-Step, LH
 Start Date: 7/05/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 16 9-85 17/07/14		24 LH			
240 *240* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4X Ø LH			M-F 12/09/14
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7:50 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:20	0.00 0.00				4X Ø LH			M-F 12/09/17

W121841

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Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 7/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>N122500</u> Memo	0.00				<u>4/6/11</u>	<u>6</u>	<u>12/09/11</u>	<u>11/17/11</u>
270 *270* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				<u>4/6/11</u>	<u>6</u>	<u>12/09/11</u>	<u>11/17/11</u>
280 *280* Packaging Packaging	Pick Kit Memo	0.00				<u>4</u>		<u>12/09/11</u>	<u>11/17/11</u>



Work Order ID 86557


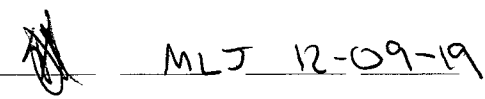
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July-05-12 10:22:51 AM

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Heli-Access-Step, LH
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 Required Date: 7/20/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 *290* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				<u>44</u> LH			
300 *300* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-591-121 Location: _____ PPP Rev: <u>E</u>	0.00 0.00				<u>44</u>			<u>SP</u> <u>12-9-18</u>
310 *310* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>MLJ 12-09-19</u> <u>MP</u> <u>12-09-19</u>

Picklist Print

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Work Order ID: 86557

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			110	Each	70.5000	0.5	2.1052632		12.07.05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		70.5							
				80803		70.5				2.1053			
D2850-1 End Bracket		Manufactured	No			140	Each	3.0000	1	4		12.09.06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA016		3							
				68490		3							
* D2582 Step Leg Assembly		Manufactured	No			190	Each	11.0000	1			12.09.06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA014		11							
				72804		8							
				72828		3							
MS20600-AD4W3 Cherry Rivets		Purchased	No			190	Each	1,288.0000	16			12.09.06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314		564							
				122151		564							
				ST321		591							
				111636		36							
				117601		3							
				118626		294							
				120308		258							
				WA018		133							
				107939		133							

Picklist Print

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Work Order ID: 86557

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 4.00

Required Qty: 4.00

D2673-34
End Plate

Manufactured No

210 Each 79.0000 1 4

12.09.07

Location Loc Qty Loc Code

WA 79

84535 79

AN4-16A

Bolt

Purchased No

290 Each 127.0000 2 8

Location Loc Qty Loc Code

ST358 127

120498 14

121444 63

121541 50

D2856-400

Abrasion Strip

cut (1) at 7.20"

Manufactured No

290 f 168.8425 0.6 2.4

2 x 89352 JB

Location Loc Qty Loc Code

ST403 159.398

81875 159.398

ST409 9.4445

63735 0.6696

68076 0.3149

71164 8.46

2 x 81875

AN960JD416

Washer

NAS1149D0463J

Purchased No

290 Each 29.0000 6 24

122452 JB

Location Loc Qty Loc Code

ST351 29

116289 8

119097 21

D2230-1

Lug

Manufactured No

290 Each 240.0000 8 4

12/09/18 JB

Location Loc Qty Loc Code

ST480 240

84135 40

84136 200

84136

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Shop Packet Print

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Picklist Print

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Work Order ID: 86557

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 4.00

Required Qty: 4.00

AN3-37A
Bolt

Purchased No

290 Each 467.0000

2 8 JB SP

Location

Loc Qty

Loc Code

ST353

467

117619

4

119086

463

119086

MS21042L3
Nut

Purchased No

290 Each 3,330.0000

2 8 JB SP

Location

Loc Qty

Loc Code

ST300

1330

117885

32

119017

771

119075

138

121444

389

ST317

2000

122141

2000

122141

AN4-13A
Bolt

Purchased No

290 Each 1,143.0000

3 12 JB SP

Location

Loc Qty

Loc Code

ST357

1143

120187

19

120422

2

120770

12

121652

912

122063

198

MS21042L4
Nut

Purchased No

290 Each 1,705.0000

3 12 JB 12/09/18

Location

Loc Qty

Loc Code

ST300

1705

119075

116

121011

193

121444

1096

121652

300

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Shop Packet Print

Page 3

Picklist Print

July-05-12 10:22:50 AM

Page 4

Work Order ID: 86557

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Lug

Manufactured No

290 Each 158.0000

89045 JB

Location

Loc Qty

Loc Code

ST480

158

83261

2

84133

156

D2732-030

Rubber Cushion

cut (2) at 3.00"

Manufactured No

290 Each 28.0000

83560 JB

Location

Loc Qty

Loc Code

ST402

28

84498

28

AN960JD10

Washer

NAS1149D0363J

Purchased

No

290 Each 0.0000

122378 JB 12/09/18

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

D2351

RELEASED
05.11.28 #PH
ECN 1105**UNDER REVIEW**

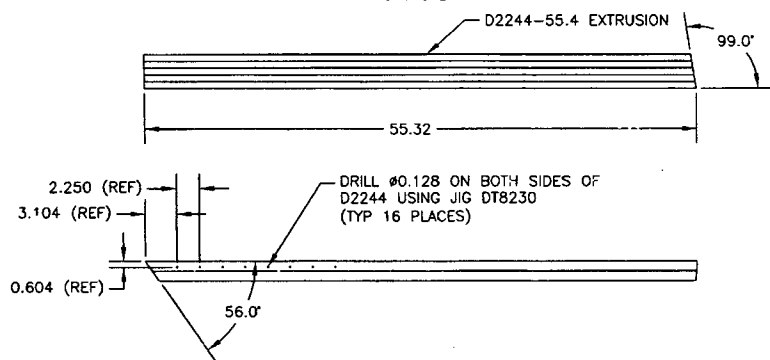
07.11.29 #

PER LIC # 263

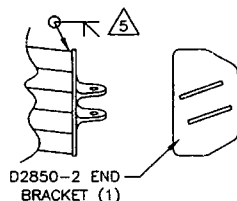
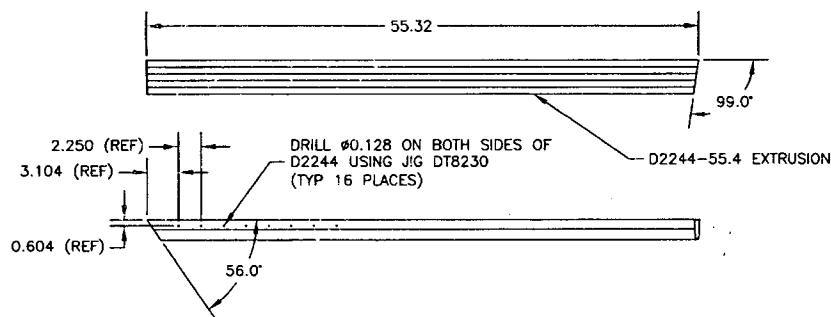
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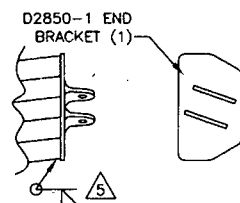
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



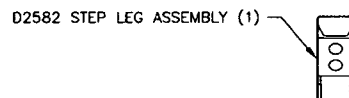
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



DETAIL B
SCALE: 1:4

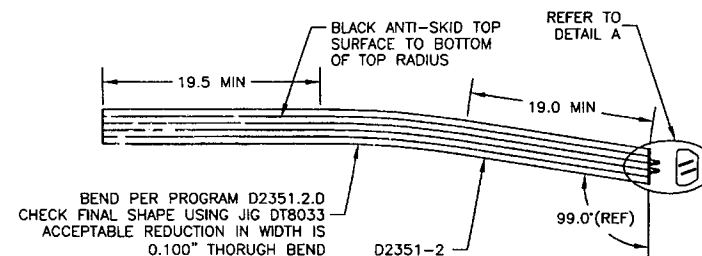


GENERAL NOTES

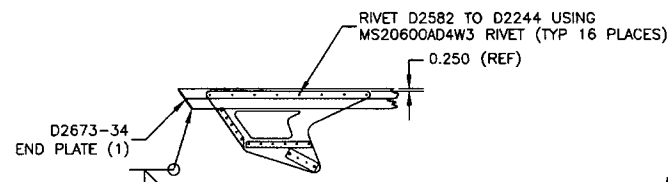
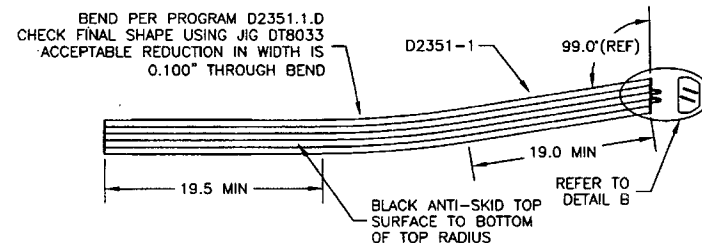
- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

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DESIGN KE	DRAWN BY FH	DART	DART AEROSPACE LTD. HARNESSBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12	

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G

Date: 08.10.06

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

REFERENCE ONLY

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD	
DRAWN	<i>92</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PL</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>N/A</i>	DSI 9459	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OPTIONAL CLAMP MODIFICATIONS	NTS
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